

Date: Tuesday, 1/9/2007 4:06:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 30213
 Estimate Number : 10531
 P.O. Number : N/A Part Number : D2572
 This Issue : 1/9/2007 S.O. No. : N/A Drawing Number : D2572 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 30095 Material : N/A
 Due Date : 1/30/2007 Qty: 12 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature] 07.01.09
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: B05350

J.F. 12.8 07/01/22

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 30213 Double check by: [Signature]

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

J.F. 12.8 07/01/22 (12)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

J.F. 12.8 07/01/22 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod / Machine ^{PTIS} NCR: (Yes) No DQA: 4 Date: 07/02/07
 QA: N/C Closed: 4 Date: 07.02.07

NCR: <u>30213</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-22	2.0	Dim Thickness ^{min} .115 is .108 min. .352 is .342. R.C. Roughly .010 too much was removed from the surface to start casing a .010 offset on the origin.	<i>[Signature]</i> QS1042	1 saddle only - the 1st one part acceptable.	S.F. 07/01/23	<i>[Signature]</i> 07-01-23	<i>[Signature]</i> QS1042	<i>[Signature]</i> 07-01-22
07/01/26	2.0	operation 2.0, origin off, resulting in scraping part. <u>TOTALTY</u>	<i>[Signature]</i> QS1042	Scrap on replacement. 2nd machine from 1st NC. destroy what's left, & no need to replace.	S.F. 07/01/26	<i>[Signature]</i> 07-02-01	<i>[Signature]</i> QS1042	<i>[Signature]</i> 07-02-01

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 4:06:41 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30213

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F./J.F.

07/01/27

(12)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/01/28

X12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.A./Y

07/02/02

(12x)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M1103141

M.A./Y

07/02/05

(12x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/02/06

(1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S1472

07/02/06 (2x)

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/07

(12)

Job Completion



07-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30213
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	.439	Ø.440"	Ø.440	Ø.440		
B	1.745	1.755		1.750	1.751"	1.751	1.749		
C	3.495	3.505		3.500	3.500"	3.500	3.500		
D	1.745	1.755		1.750	1.751"	1.751	1.750		
E	7.990	8.010		8.000	8.003"	8.003	8.002		
F	0.490	0.510		.501	.500	.506	.500		
G	0.257	0.262	DT8683	.258	Ø.260"	Ø.260	Ø.260		
H	0.375	0.380	DT8684	.376	.376"	Ø.376	Ø.376		
I	0.490	0.510		.500	.494"	.495	.496		
J	1.174	1.184		1.179	1.181"	1.181	1.180		
K	0.558	0.578		.568	.569"	.569	.567		
L	1.174	1.184		1.179	1.181"	1.181	1.180		
M	1.490	1.500		1.495	1.499"	1.499	1.495		
N	2.495	2.505		2.500	2.502"	2.502	2.500		
O	3.869	3.879		3.875	3.877"	3.877	3.870		
P	0.115	0.135		.125	.123"	.120"	.121		
Q	0.115	0.135		.125	.135"	.135	.125		
R	0.240	0.260		.252	.251"	.249"	.248		
S	0.115	0.135		.125	.130"	.129"	.128		
T	0.178	0.198		.188	.188"	.188"	.188		
U	2.940	2.980		2.965	2.963"	2.963"	2.964		
V	0.230	0.250		.240	.230	.233"	.235		
W	0.115	0.135		.120	.120"	.120	.131		
X	0.307	0.312		.312	.312"	.312	.310		
Y	0.760	0.765		.764	.764"	.764	.760		
Z	0.352	0.372		.367	.367"	.367	.371		
AA	0.470	0.530		.500	.500"	.500"	.500		
AB	0.615	0.635		.626	.627"	.627	.627		
AC	0.053	0.073		.063	.063"	.063"	.063		
AD	0.240	0.260		.250	.249"	.240"	.250		
AE	1.375	1.395		1.394	1.388"	1.387	1.385		
AF	0.115	0.135		.125	.125"	.125	.125		
AG	0.240	0.280		.250	.250"	.250"	.250		
AH	0.240	0.260		.250	.251"	.240"	.242		
AI	2.000	2.020		2.001	2.000"	2.001"	2.001		
AJ	0.023	0.043		.025	.025"	.025	.025		

Accept/Reject

Measured by:	S.F./J.F.
Date:	07/01/22

Audited by:	En
Date:	07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30213
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	.438	.438	.439	.438		
B	1.745	1.755		1.750	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.751		
E	7.990	8.010		8.002	8.002	7.999	7.999		
F	0.490	0.510		.501	.501	.500	.501		
G	0.257	0.262	DT8683	.258	.258	.257	.259		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.497	.497	.497	.504		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.559	.559	.559	.559		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.495		
O	3.869	3.879		3.875	3.873	3.873	3.873		
P	0.115	0.135		.121	.121	.121	.120		
Q	0.115	0.135		.128	.128	.128	.125		
R	0.240	0.260		.252	.252	.252	.251		
S	0.115	0.135		.128	.128	.126	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.242	.242	.242		
W	0.115	0.135		.129	.129	.129	.129		
X	0.307	0.312		.310	.310	.310	.312		
Y	0.760	0.765		.760	.760	.760	.764		
Z	0.352	0.372		.360	.360	.367	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.620	.620	.620	.621		
AC	0.053	0.073		.060	.060	.060	.060		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.377	1.377	1.377	1.377		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.240		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.030	.030	.030	.033		
Accept/Reject									

Measured by: J.F. 07/01/27
Date:

Audited by: Ep
Date: 07/01/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30213
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

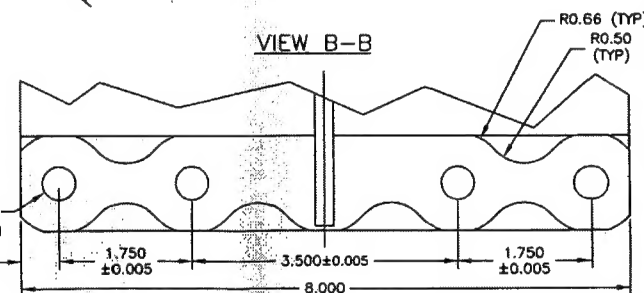
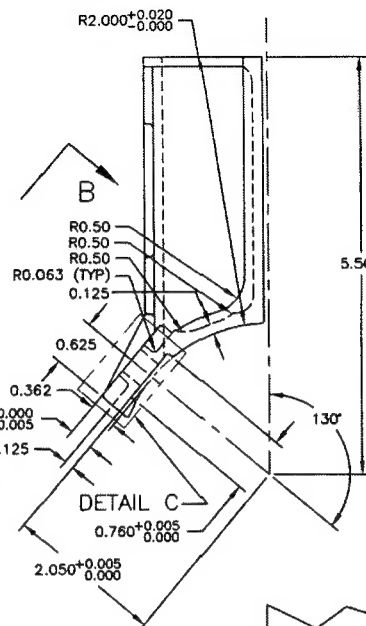
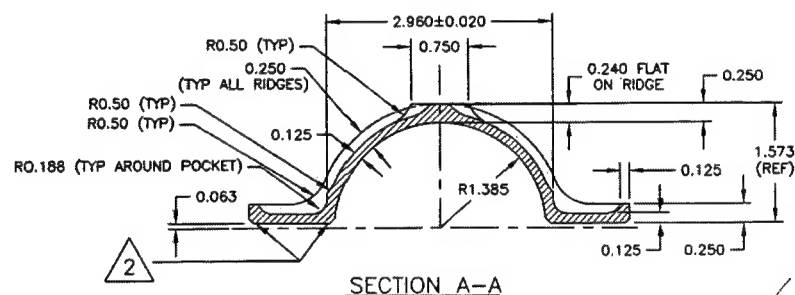
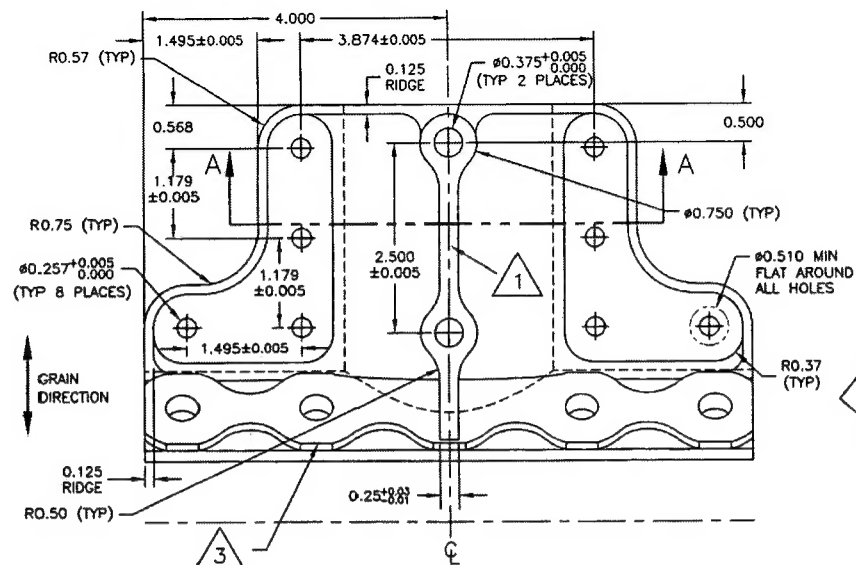
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440"	0.440"	0.440"	0.440"		
B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500"	3.500"	3.500"	3.500"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.003"	8.003"	8.003"	8.003"		
F	0.490	0.510		0.498"	0.505"	0.500"	0.500"		
G	0.257	0.262	DT8683	0.258"	0.260"	0.260"	0.260"		
H	0.375	0.380	DT8684	0.375"	0.376"	0.376"	0.376"		
I	0.490	0.510		0.501"	0.498"	0.501"	0.500"		
J	1.174	1.184		1.180"	1.180"	1.180"	1.180"		
K	0.558	0.578		0.570"	0.563"	0.567"	0.570"		
L	1.174	1.184		1.178"	1.178"	1.178"	1.178"		
M	1.490	1.500		1.500"	1.500"	1.500"	1.500"		
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
O	3.869	3.879		3.872"	3.872"	3.872"	3.872"		
P	0.115	0.135		0.125"	0.121"	0.123"	0.123"		
Q	0.115	0.135		0.125"	0.135"	0.135"	0.135"		
R	0.240	0.260		0.252"	0.254"	0.255"	0.254"		
S	0.115	0.135		0.130"	0.129"	0.129"	0.129"		
T	0.178	0.198		0.184"	0.188"	0.188"	0.188"		
U	2.940	2.980		2.960"	2.963"	2.963"	2.963"		
V	0.230	0.250		0.247"	0.248"	0.244"	0.243"		
W	0.115	0.135		0.122"	0.122"	0.122"	0.122"		
X	0.307	0.312		0.312"	0.312"	0.312"	0.312"		
Y	0.760	0.765		0.764"	0.764"	0.764"	0.764"		
Z	0.352	0.372		0.367"	0.364"	0.364"	0.364"		
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"		
AB	0.615	0.635		0.622"	0.626"	0.628"	0.627"		
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"		
AD	0.240	0.260		0.250"	0.251"	0.249"	0.250"		
AE	1.375	1.395		1.380"	1.382"	1.384"	1.384"		
AF	0.115	0.135		0.130"	0.130"	0.130"	0.130"		
AG	0.240	0.280		0.250"	0.250"	0.250"	0.250"		
AH	0.240	0.260		0.250"	0.257"	0.253"	0.252"		
AI	2.000	2.020		2.001"	2.001"	2.001"	2.001"		
AJ	0.023	0.043		0.033"	0.023"	0.023"	0.023"		
Accept/Reject									

Measured by:	J.F. / J.B.
Date:	07/01/26

Audited by:	Ed
Date:	07/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

DETAIL C
SCALE 2:1

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DESIGN	DRAWN BY	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DS	PH		
CHECKED	APPROVED	DRAWING NO.	REV.
		D2572	
			SHEET 1 OF
DATE		TITLE	SCALE
05.07.13		INNER FWD SADDLE	2:

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NO. 30213